

Work Order ID 82048

March-22-12 10:34:41 AM

82048

Page 1

Item ID: D2573

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Aft Out 205

Start Date: 22/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/22 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

82048

0.00

HAAS CNC vertical machine #1

Program Batch No. 82048 Double check by: SA 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
Machine Step No 3 per Folio FA051 and insp

ML/BG
12/04/09
B.A 12/04/12

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

ML/BG
12/04/09
B.A 12/04/12

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ML/BG
12/04/09
B.A 12/04/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82048

March-22-12 10:34:41 AM

82048

Page 2

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 22/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	JL 12-04-15						
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	(12) HG 12-4-16						
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:45 FINISH TIME: 4:15	0.00 0.00	12x ✓ M-L 12/04/16						

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82048

March-22-12 10:34:41 AM

82048

Page 3

Item ID: D2573

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Aft Out 205

Start Date: 22/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12x d All work

170

Identify as per dwg & Stock Location:

SYB3

0.00

170

Packaging

Memo

0.00

Packaging

12x SP 12-04-17

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/17 MF 12-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-22-12 10:34:45 AM

Page 1

Work Order ID: 82048

82048

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	53.0000	1	12			

D6101-007

Saddle Billet

**

36

12/04/09

Location	Loc Qty	Loc Code
MAT042	48	
79589	20	
79875	28	
MAT045	5	
70680	3	
76839	2	
61994		

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	82048
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.501	.500	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.505	.505	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.572	.572	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.243	.243	.242	.247		
S	0.115	0.135		.126	.126	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.240	3.240	3.240	3.240		
V	0.230	0.250		.242	.242	.237	.237		
W	0.115	0.135		.125	.125	.128	.126		
X	0.308	0.313		.310	.310	.310	.308		
Y	0.760	0.765		.761	.761	.760	.760		
Z	0.352	0.372		.362	.362	.359	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.622	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.249	.246	.246		
AE	1.500	1.520		1.510	1.510	1.510	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.245	.248	.247	.246		
AI	2.000	2.020		2.003	2.003	2.005	2.004		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	RF
Date:	12/04/08

Audited by:	JL
Date:	12-04-15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 82048
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.503	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.566	.566	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.124	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.247	.247	.248	.247		
S	0.115	0.135		.126	.127	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.236	.239	.238	.238		
W	0.115	0.135		.127	.126	.127	.129		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.362	.361	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.622	.623	.622		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.246	.247	.247		
AE	1.500	1.520		1.513	1.515	1.515	1.512		
AF	0.115	0.135		.126	.130	.130	.130		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.246	.248	.248	.248		
AI	2.000	2.020		2.0032	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	ML
Date:	12/04/10

Audited by:	SL
Date:	12-04-15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	82048
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

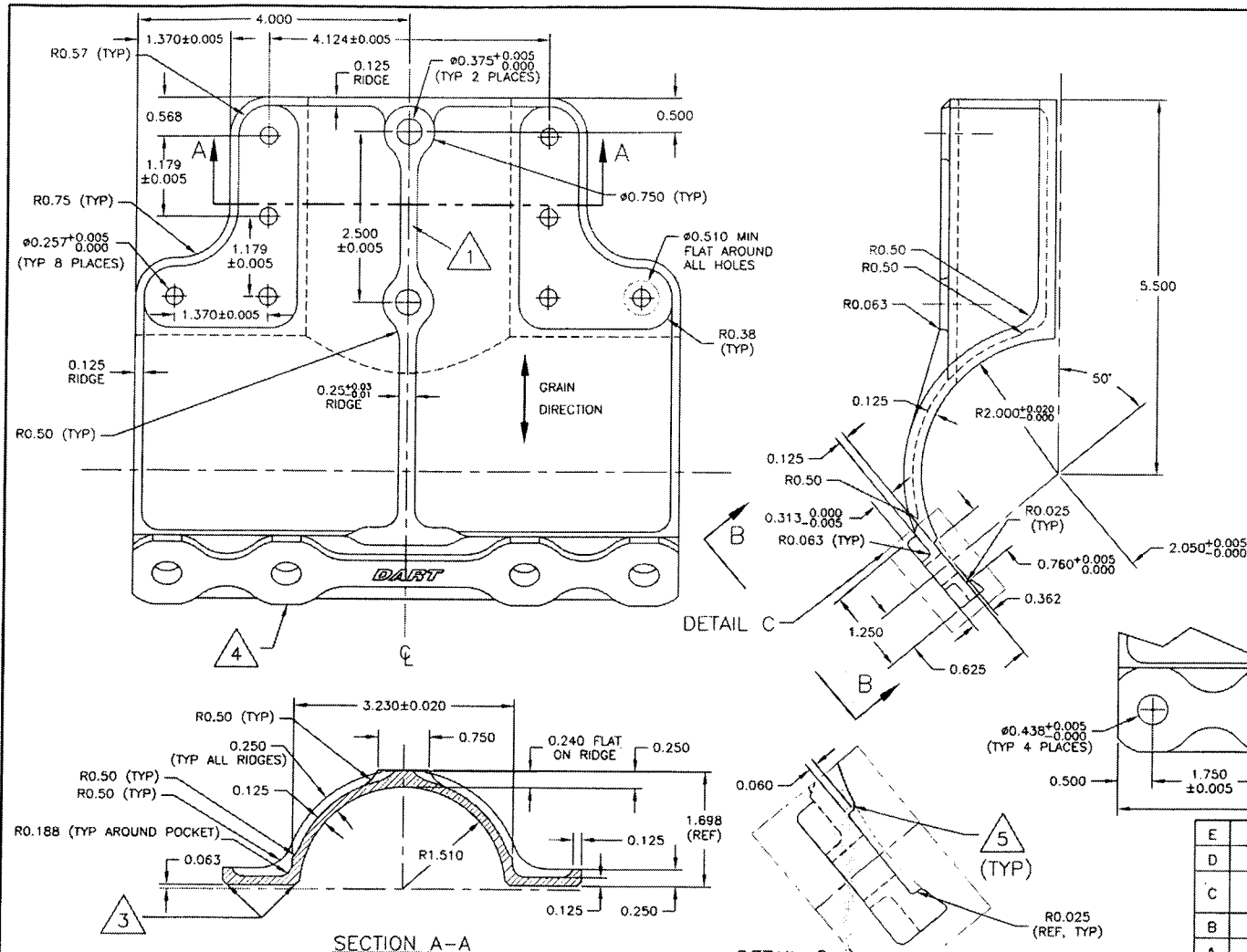
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A9	A10	A11	A12	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.500	0.500	0.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.503	.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.569	.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.125	.125	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.249	.247	0.248		
S	0.115	0.135		.127	.127	.128	0.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.238	.238	.239	0.238		
W	0.115	0.135		.127	.127	.127	0.127		
X	0.308	0.313		.309	0.309	0.309	0.309		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		.360	0.361	0.362	0.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	0.622	0.622	0.622		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.245	0.246		
AE	1.500	1.520		1.5123	1.512	1.515	1.513		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.275	.275	.275	0.275		
AH	0.240	0.260		.248	.247	.248	0.247		
AI	2.000	2.020		2.003	2.0035	2.0023	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>ML</i>	Audited by: <i>SL</i>
Date: 12/04/10 / 12/04/17	Date: 12-04-15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

RELEASED

05.12.06



NOTES

MATERIAL: 7075-17351 (QQ-A-250/12)

(REF DART SPEC. D6102-001)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER

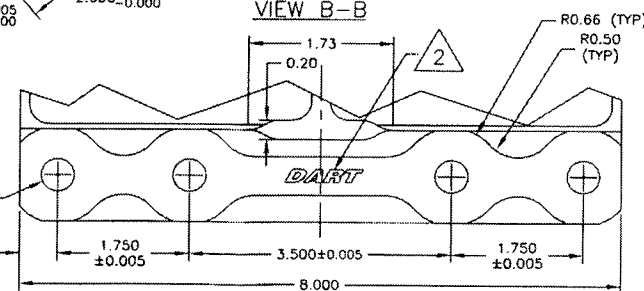
DART QSI 005 4.3

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2573
		TITLE OUTER AFT SADDLE
		SCALE 2:3

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82048 MLJ

12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries